

# Work Order ID 78435

**\*78435\***

Page 1

January-09-12 1:57:55 PM

Item ID: D2512 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Basket Lid 205/350  
 Start Date: 09/01/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 16/01/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference: -

Approvals: Process Plan: M.L.J Date: 12/01/09 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2512	Rev E

100 Weld per dwg A/R S.S. rod Batch: 4115778 0.00

**\*100\***

Large Fab

Large Fab

Memo 0.00

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512  
 2-Cut (4) D2236 From D3166-3  
 3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305  
 4-Weld as per Dwg D2512 using Welding Jig DT 9436  
 Deburr as required  
 \*\*\*INSTALL D2012-117 CLEVIS ONLY ON D130-701-041\*\*\*

SS 12-01-16 (12)

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*110\***

QC

Quality Control

Memo 0.00

Pl 12-01-16/17 1x Ø

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 78435****\*78435\***

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Item ID: D2512

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Basket Lid 205/350

Start Date: 09/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Memo

0.00

Quality Control

8 12/04/17

125

Pressure Wash per QSI005 4.3

0.00

**\*125\***

HandFinish

Memo

0.00

Hand Finishing

1X Ø m-l 12/04/17

**Dart Aerospace Ltd**

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130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
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**\*130\***

Powdercoat

Powder Coating

**Memo**

0.00

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 2:20OVEN TEMPERATURE: 400°FFINISH TIME: 2:50

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

*1/12 M/L 12/01/17*

140	HandFinishing	0.00							
-----	---------------	------	--	--	--	--	--	--	--

**\*140\***

HandFinish

Hand Finishing

**Memo**

0.00

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: 120125*1 BL 12-1-18.**m119480*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

160	Identify as per dwg & Stock Location <b>0350-607-041</b> <b>78418.</b>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									

170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

*MF*  
*12-01-20*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1

Work Order ID: 78435

**\*78435\***

Parent Item: D2512

**\*D2512\***

Parent Item Name: Basket Lid 205/350

Start Date: 09/01/2012

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

**Comments:** Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF  
 IPP Rev:N06.04.05 Added level21 EC  
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM  
 VERIFIED BY:DD  
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC  
 IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified  
 by:EC IPP Rev:R  
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2012-117		Manufactured	No			100	Each	35.0000	2	2			
<b>*D2012-117*</b>									<b>**</b>	N/A			
Clevis													

Location	Loc Qty	Loc Code
WA005	35	
55729	4	
69890	31	

\*\*\* ONLY APPLICABLE ON D130-701-041 -IF  
 NOT USED, PLEASE MARK N/A \*\*\*

D2232-1		Manufactured	No			100	Each	2.0000	2	2			
<b>*D2232-1*</b>									<b>**</b>	12-01-11			
Basket Hinge													

Location	Loc Qty	Loc Code
WA005	2	
70842	2	

D2327-1		Manufactured	No			100	Each	41.0000	2	2			
<b>*D2327-1*</b>									<b>**</b>	12-01-11			
Spacer Bushing													

Location	Loc Qty	Loc Code
WA005	41	
69728	15	
73692	26	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 2

Work Order ID: 78435

**\*78435\***

Parent Item: D2512

**\*D2512\***

Parent Item Name: Basket Lid 205/350

Start Date: 09/01/2012

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D2506  
**\*D2506\***  
Label Plate

Manufactured No 100 Each 5.0000 1 1

\*\*

*SY 12.01.01*

Location

Loc Qty

Loc Code

WA006

5

74142

5

1x

Manufactured No

100 Each

81.0000

2

2

\*\*

*SY 12.01.11*

✓ D2581  
**\*D2581\***  
Mounting Bracket

Location

Loc Qty

Loc Code

WA005

81

69739

1

70766

2

75280

1

77045

48

77523

29

2x

Manufactured No

100 Each

3.0000

1

1

\*\*

*B70189 SY 12.01.12*

\* D3166-3  
**\*D3166-3\***  
Basket Hoop

Location

Loc Qty

Loc Code

WA007

3

73627

3

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 78435

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

**\*78435\***

**\*D2512\***

Start Date: 09/01/2012

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

493.8700

18

18.94737

**\*M304EX0 75-16F\***

Expanded Metal Flat SS

\*\*

*[Signature]* 12.01.11

Location

Loc Qty

Loc Code

WA

0.0001156

119180

0.0001156

WA035

493.8699277

117197

102.9036

117896

38.3264

118153

76.8473

118248

3.0983

118597

21.06788

118955

82.17

119180

59.1168634

119729

110.339584

M304TS0.750W.065

Purchased

No

100

f

160.1227

43.5804

45.87411

**\*M304TS0 750W 065\***

304 SQ Tube .75x.75x.065W

\*\*

*[Signature]* 12.01.11

Location

Loc Qty

Loc Code

MAT018

138.4584785

117636

67.9987

118773

70.4597785

WA007

15.5974906

116267

14.628472

116763

0.9690186

WA035

6.0667

118181

6.0667

45.87 + 1 END BAR SCRAP

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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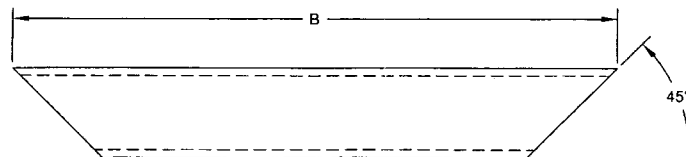
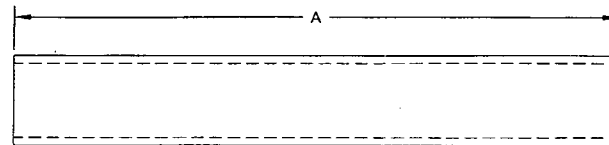
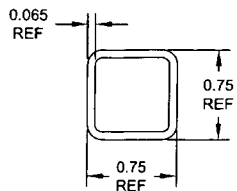
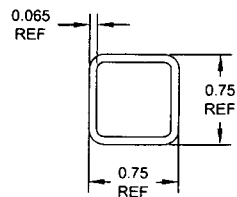
# PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO 38435M.L.5  
12/01/09

RELEASED  
08-06-21-117



## D2512-1/-3/-5/-7 NOTES:

- MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- FINISH: N/A
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: N/A
- CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

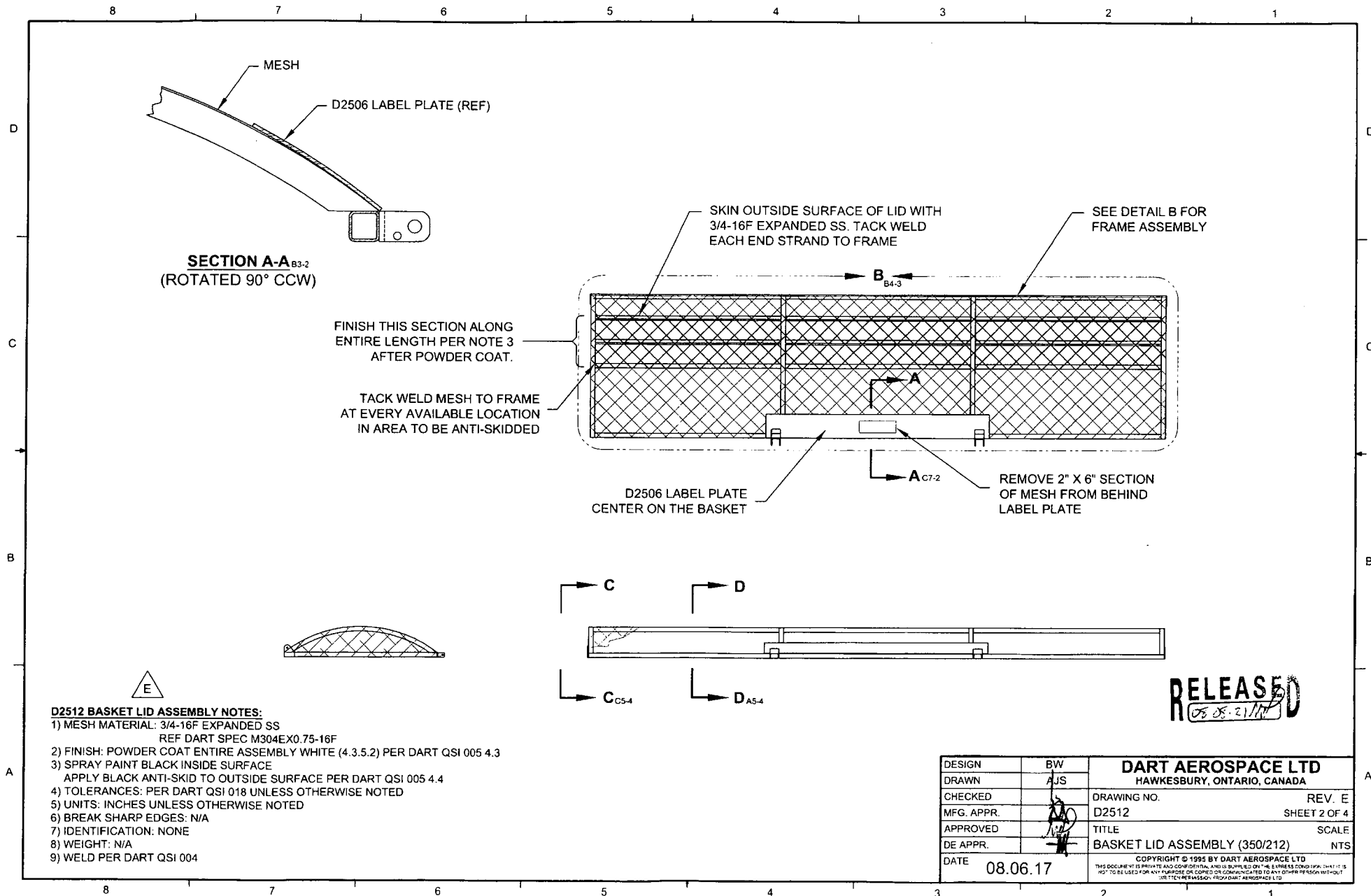
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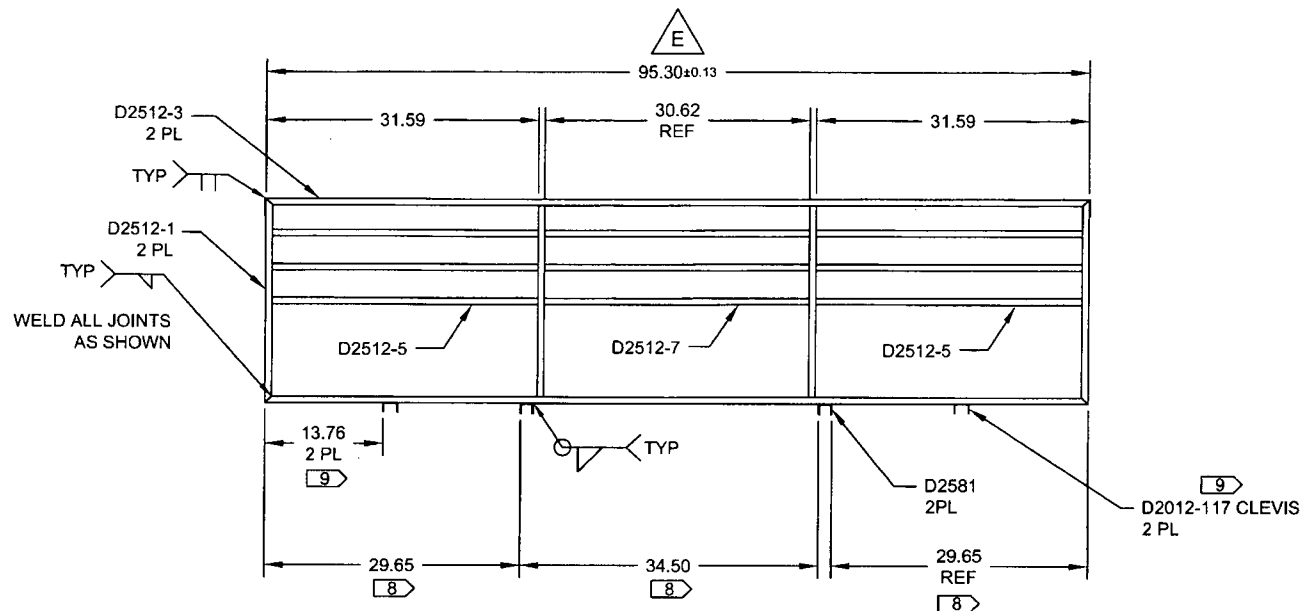
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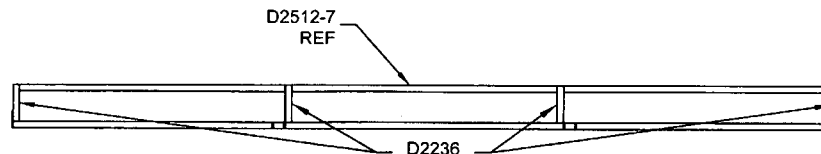
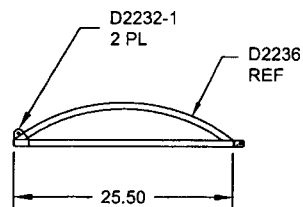
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**DETAIL B** C3-2  
FRAMEWORK ONLY SHOWN FOR CLARITY



- NOTES:**
- 1) MATERIAL: NONE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: N/A
  - 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
  - 9) FOR D130-701-041 ONLY

**RELEASED**  
08-06-17

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	10	D2512	SHEET 3 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	10	BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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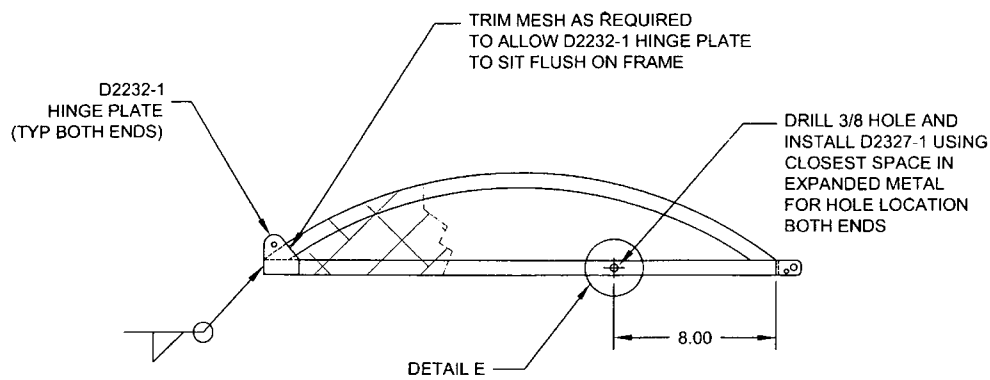
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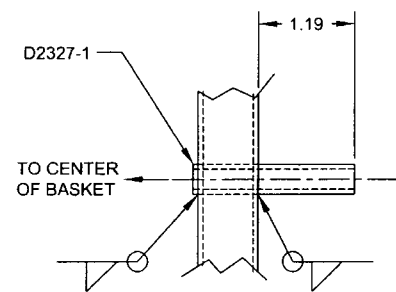
**NOTE:** Date & initial all entries

78435

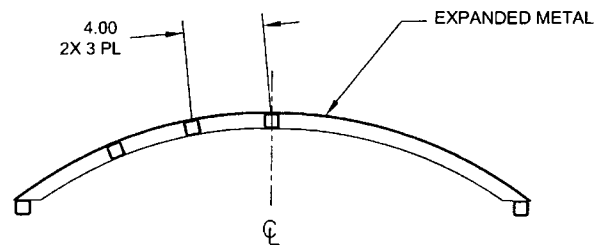
8 7 6 5 4 3 2 1



**VIEW C-C SIMILAR BOTH END RIBS** A5-2



**DETAIL E** C6-4



**SECTION D-D SAME BOTH CENTER RIBS** A4-2

**RELEASED**  
08.06.17

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries